

Shp 12/07

Dart Aerospace Ltd.

Date: Wednesday, 11/07/2007 6:30:28 AM  
User: Linda Lacelle



# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HOUSING WELDMENT
<b>Job Number</b> : 32219	
<b>Estimate Number</b> : 11874	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D2207041
<b>This Issue</b> : 11/07/2007 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : D2207 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 03/05/2007 <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : C
<b>Previous Run</b> :	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : <i>[Signature]</i>	<b>Due Date</b> : 10/05/2007 <b>Qty:</b> 5 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>[Signature]</i>	
<b>Comment</b> : Est. C 01.10.18 Added Step 10 and 11 SM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2208	End Cap
  <p><b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) End Cap Pick: Qty Part Number Description Batch 2 D2208 End cap <i>33239</i></p> <p><i>07/07/11</i> <i>[Signature]</i> (5)</p>		
2.0	D22071	Housing
  <p><b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Housing Pick: Qty Part Number Description Batch 1 D2207-1 Housing <i>33240</i></p> <p><i>07/07/11</i> <i>[Signature]</i> (5)</p>		
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
  <p><i>Rod</i> <i>B102756</i> <i>16.01.07.12</i></p> <p><b>Comment:</b> LARGE FABRICATION RESOURCE 1 Weld as per Dwg D2207 Grind welds flush as per Dwg D2207</p> <p><i>07/07/11</i> <i>[Signature]</i> (5) <i>FF 07-07-12 - SAP 07/07/12</i></p>		
4.0	QC9	VISUAL WELDING INSPECTION
  <p><b>Comment:</b> VISUAL WELDING INSPECTION</p> <p><i>PD</i> <i>07-07-12</i> (5)</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOUSING WELDMENT

Job Number: 32219

Part Number: D2207041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



PTC

Comment: LARGE FABRICATION RESOURCE 1

Drill holes using DT8557 as per Dwg D2207

FF 07-07-12 5

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FD 07/07/12 (5)

7.0

POWDER COATING

POWDER COATING



(5)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR 07-07-12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 07/07/12 (5)

9.0

ALS71032130

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Insert

Qty Part Number Description Batch

4 DAK57-1032-130 Insert

M6087

SB 07/07/12 (5)

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Install AK57-1032-130 as per Dwg D2207

FF 07-07-12

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/07/12 (5)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/07/12 (5)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng Prod Mgr	Approval QC Inspector
07-07-12	5.0 5.1	Add QCS after drilling. Perm Change		07-08-12		07-07-12	07-07-12

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07-07-12

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOUSING WELDMENT

Job Number: 32219

Part Number: D2207041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



(5)  
R 07/09/12  
u 07-07-12



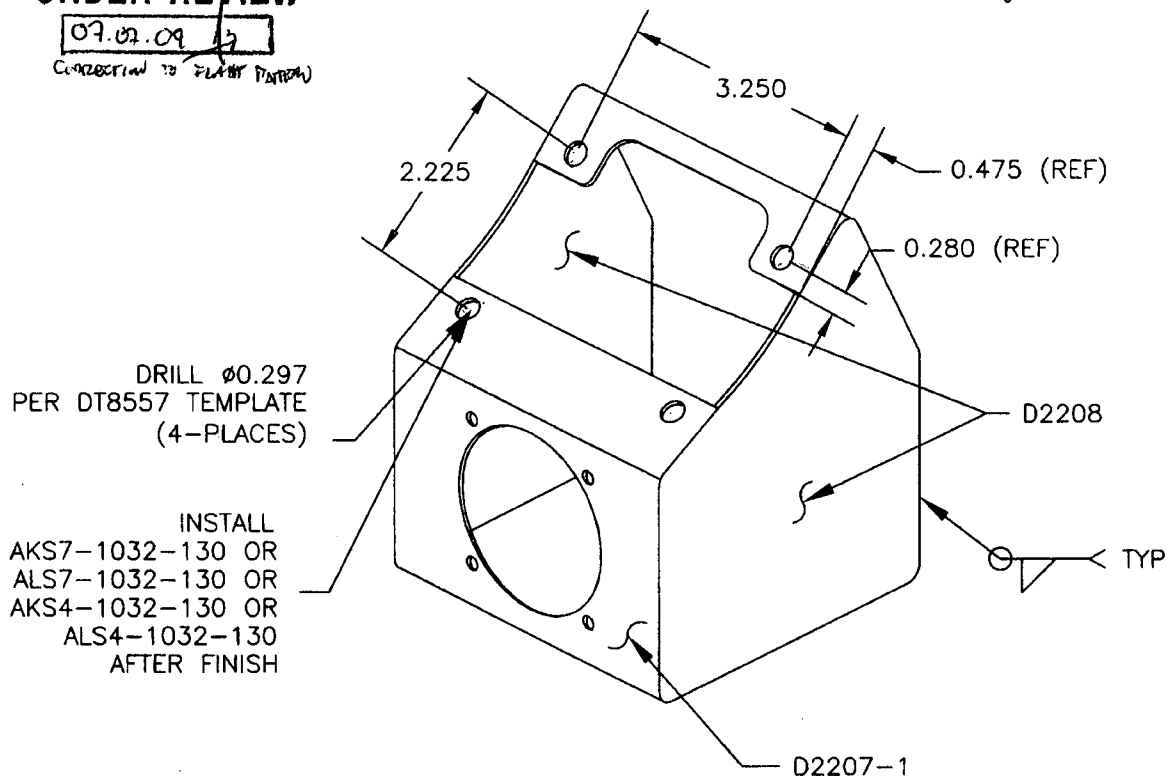
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2207	REV. B SHEET 1 OF 2
DATE 01.02.23		TITLE HOUSING	SCALE 1:2
A	94.09.01	NEW ISSUE	
B	01.02.23	REDRAWN	

**RELEASED**  
01.02.27 *[Signature]*

**UNDER REVIEW**

07.02.09 *[Signature]*  
CONNECTION TO FLAT PATTERN

*w/03229*



D2207-041 ASSEMBLY

**NOTE:**

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT CLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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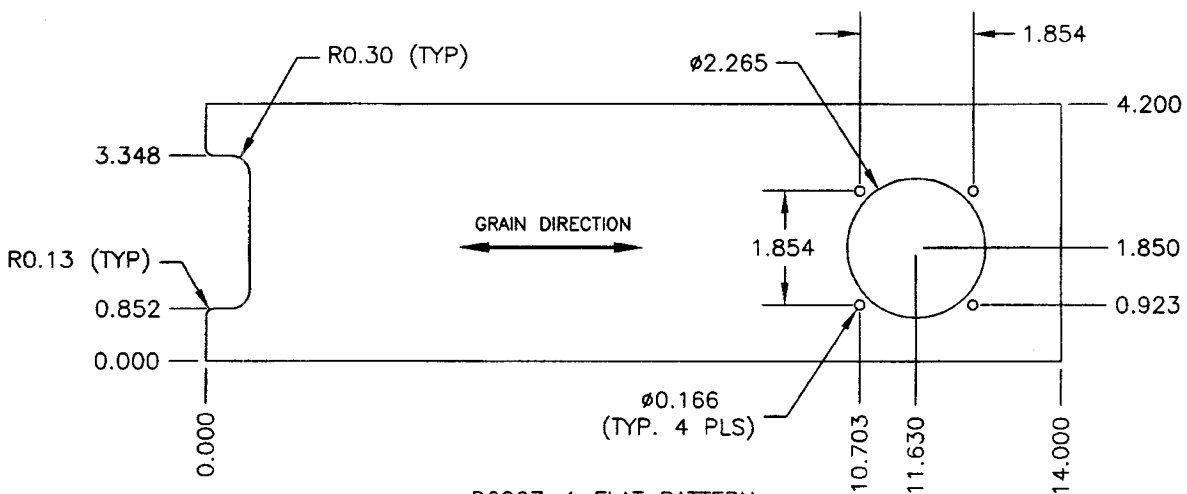
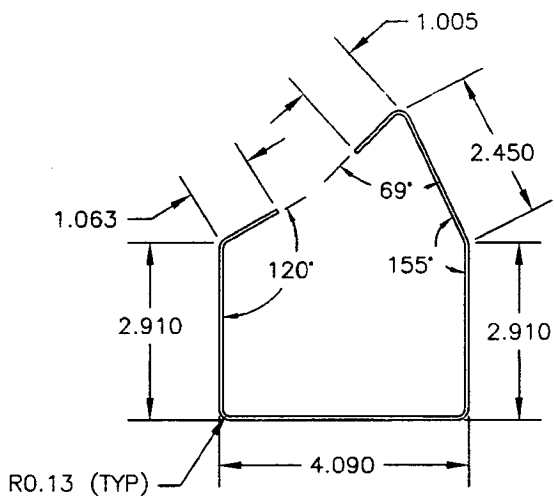
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01.02.27

**UNDER REVIEW**

03.07.09 13



MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) ALUMINUM 0.063 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2207	REV. B SHEET 2 OF 2
DATE 01.02.23	TITLE HOUSING		SCALE 1:3

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